

Work Order ID 59548

Monday, June 07, 2010 1:36:38 PM



SHIP WEDU

Page 1

Item ID:	D3911-043	Accept		Setup	Start	
Revision ID:						
Item Name:	Aft Eyebolt Receiver Assembly				Stop	
Start Date:	6/7/2010	Start Qty:	5.00			
Required Date:	6/8/2010	Req'd Qty:	5.00			
Reference:						

Approvals:	Process Plan:	<u>MF</u>	Date:	<u>10-6-7</u>	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3911	C								
100	Pick Kit	0.00							
Packaging	Memo	0.00							
Packaging									
110		0.00							
Small Fab	Memo	0.00							
Small Fab	1- Assemble D3911-5 to D3911-3 and install rivet as per dwg Trim rivet to 1.250" Full Lengh								
120	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									

Ep 50/06/08 (5)

Ep 50/06/09 (5)

Solver

(5)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D3911-043

Accept

Setup Start

Revision ID:

Stop

Item Name: Aft Eyebolt Receiver Assembly

Start Date: 6/7/2010 Start Qty: 5.00

Cust Item ID:

Required Date: 6/8/2010 Req'd Qty: 5.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

Identify as per dwg & Stock Location: 507

0.00



Packaging

Memo

0.00

Packaging

(S) BB 10/06/09

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/06/10 JJ

mkf
10-6-9

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Picklist Print

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Work Order ID: 59548

Parent Item: D3911-043

Parent Item Name: Aft Eyebolt Receiver Assembly

Comments: IPP RevA: New issue DD verified by:EC
AS PER REV B 10-03-23 JLM VERIFIED BY:DD
Rev C 10-04-07 JLM Verified By:DD

IPP REV:B
IPP REV :C As per

Start Date: 6/7/2010

Required Date: 6/8/2010

Start Qty: 5.00

Required Qty: 5.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Qty per Kit	Total	Qty	Date	Status
D3911-3		Manufactured	No			100	Each	5.0000	1	5			



Aft Eyebolt Receiver

Location

Loc Qty

Loc Code

ST095

5

58787

5

100

Each

7.0000

2

10

~~D3911-7~~



Basket Plate-Eyebolt Receiver

Manufactured

No

Location

Loc Qty

Loc Code

ST095

7

57838

7

100

Each

273.0000

4

20

MS20615-4M20



RIVET

Purchased

No

Location

Loc Qty

Loc Code

ST323

273

113254

7

114324

4

114349

62

114808

200

EP 6/06/09

EP 6/06/09

B59546 (4x)
EP 6/06/09

20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

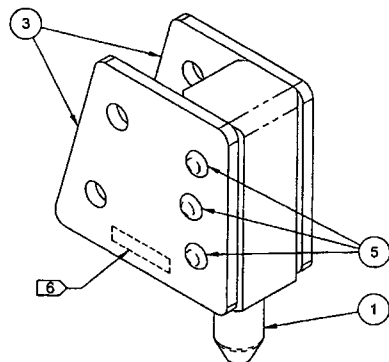
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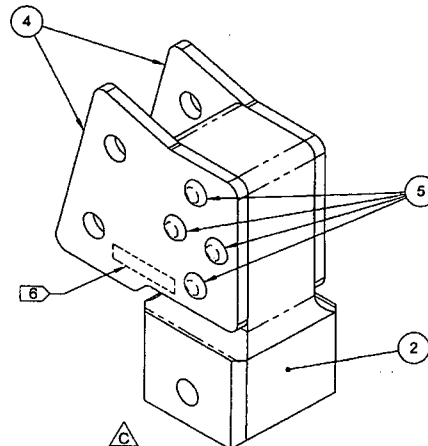
ITEM	QTY -041	QTY -043	P/N	DESCRIPTION
	X		D3911-041	BASKET INSTL STUD ASSY (LOWER)
		X	D3911-043	AFT EYEBOLT RECEIVER ASSY
1	1		D3911-1	BASKET INSTL STUD (LOWER)
2		1	D3911-3	AFT EYEBOLT RECEIVER
3	2		D3911-5	BASKET STUD PLATE
4		2	D3911-7	BASKET PLATE-EYEBOLT RECEIVER
5	3	4	MS20615-4M20	RIVET



D3911-041 BASKET INSTL STUD ASSY (LOWER)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N D3911-04X USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT -041: 0.63 lbs
-043: 0.99 lbs



D3911-043 AFT EYEBOLT RECEIVER ASSY

RELEASED
2010-04-14

C	BOM: QTY (2): D4087-1 & MS21208-C810 REMOVED FROM -043 ASSY. WEIGHT UPDATED. D3911-3 REDESIGNED. D3911-043 & D3911-3 DETAIL UPDATED. MTL SPEC ADDED TO NOTES (SHT 2). DIM 0.375 WAS 0.400 (C3-3).	JPH	10.04.06
B	DIAMETER (B3-2) AND DIM ADDED (B2-2) & (C3-2)	JPH	10.03.16
A	NEW ISSUE	JPH	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN	JPH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3911	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		AFT HARDPOINT, BASKET	NTS
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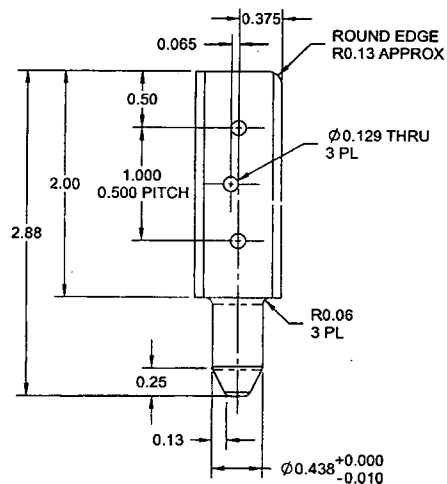
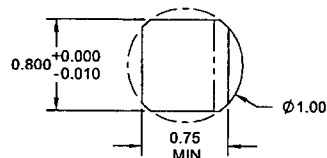
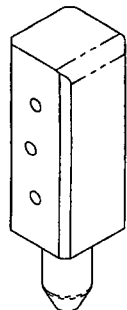
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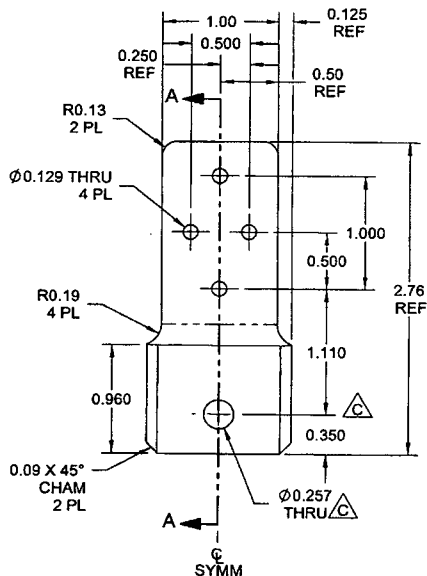
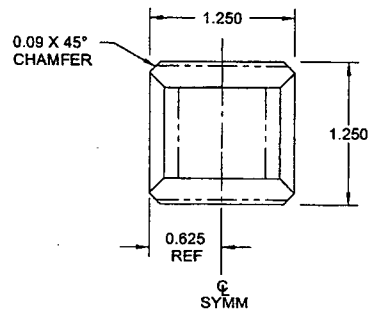
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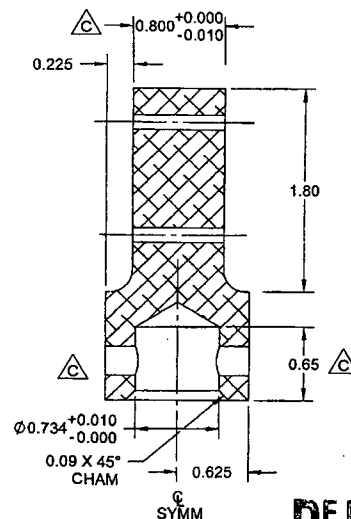
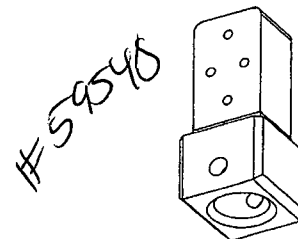
NOTE: Date & initial all entries



D3911-1 BASKET INSTL STUD (LOWER)



D3911-3 AFT EYEBOLT RECEIVER



SECTION A-A

RELEASED
2010-04-14

NOTES:

- 1) MATERIAL -1: 303/304/316 STAINLESS STEEL ROUND BAR, PER ASTM A276 OR ASTM A582
PER DART SPEC M303R OR M304R
- 3: 303/304/316 STAINLESS STEEL BAR, PER ASTM A276 OR ASTM A582
PER DART SPEC M303B OR M304B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY AT ASSEMBLY
- 7) WEIGHT -1: 0.36 lbs
-3: 0.73 lbs

DESIGN	JPH	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>[Signature]</i>	D3911	SHEET 2 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	AFT HARDPOINT, BASKET	NTS
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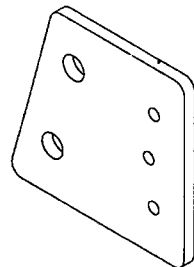
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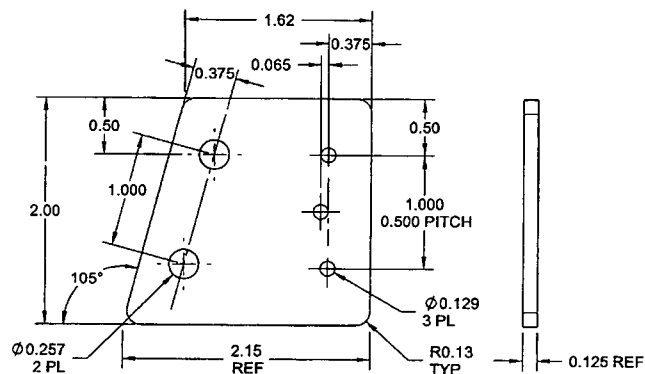
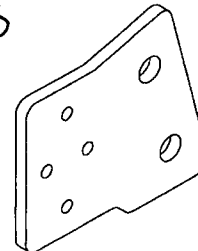
C

B

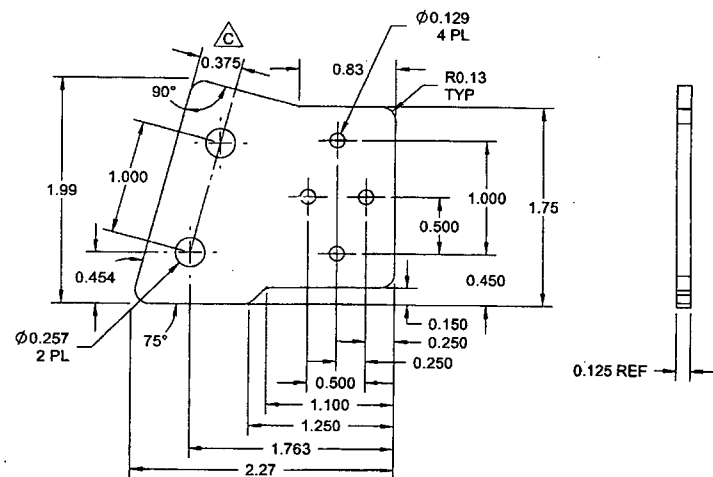
A



#59548



D3911-5 BASKET STUD PLATE



D3911-7 BASKET PLATE-EYEBOLT RECEIVER

RELEASED
2010-04-14

NOTES:

- 1) MATERIAL -5 & -7: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B, 0.125 THK
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME 5A240
PER DART SPEC M304S11GA OR M303S11GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY AT ASSEMBLY
- 7) WEIGHT -5: 0.13 lbs
-7: 0.13 lbs

DESIGN	JPH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	JPH	DRAWING NO. D3911	REV. C
MFG. APPR.			SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		AFT HARDPOINT, BASKET	NTS
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8 7 6 5 4 3 2 1

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